

SPECIFICATION AMENDMENTS*Page 8, lines 1-8:*

The laser source 110 of the DMD system is mounted above the substrate [[30]] and a layer of material [[20]] is deposited according to the description of the object. The laser has sufficient power density to create a melt pool with the desired composition of substrate or previously deposited layer and cladding powder. The cladding powder, typically metallic, is sprayed on the substrate preferably through a laser spray nozzle with a concentric opening for the laser beam, as described in U.S. Patent No. 4,724,299, and U.S. patent application Serial No. 09/671,535, so that the powder exits the nozzle co-axially with the beam.

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A numerical controller 108 controls all operating components of the DMD system of Figure 1, including the operating conditions of the laser, receiving direction from the CAD/CAM system 106 for building the part or product. The numerical controller 108 also receives feedback control signals from the feedback controller 104 to adjust laser power output, and further controls the relative position of the substrate and laser spray nozzle. A typical system further includes a laser beam redirector 112, a chiller 118 to cool the laser, a work table 114, and a power supply unit 116 feeding various subsystems shown in the figure. The CAD/CAM system 106 is equipped with software which enables it to generate a path across the substrate for material deposition. Other refinements, such as robotic handling and multiple deposition heads for simultaneous deposition onto a die surface, are depicted in Figures 3 and 4, respectively.